

Date: Tuesday, 10/06/2008 12:36:32 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING BRACKET		
Job Number	: 39777			Part Number	: D3246041		
Estimate Number	: 12473			Drawing Number	: D3246 REV A1		
P.O. Number	:			Project Number	: N/A		
This Issue	10/06/2008	S.O. No.	:	Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	11	Type	SMALL /MED FAB	Due Date	17/06/2008		
Previous Run	: 37268			Qty:	10	Um:	Each
Written By	:			(Signature)			
Checked & Approved By	:			(Signature)			
Comment	: Est Rev:A New Issue 06-06-22 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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42



Comment: Qty.: 0.3252 sf(s)/Unit Total : 3.2519 sf(s)

2024-T3 .050 sheet

Material: 2024-T3 (QQ-A-250/4) 0.050" thick
(M2024T3S.050)

Identify for D3246-1 Batch: 105646

B 8-6-10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg Dsi9279

Dwg Rev: A1

Prog Rev: A1

B 8-6-10

2-Deburr if necessary

B 8-6-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

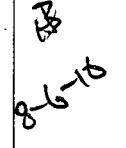
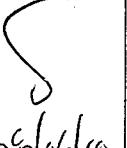
Deburr

Form as per Dwg D3246

C'sink as per Dwg D3246

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3246-041 PAR #: N/A Fault Category: Prod / Proc. Pass / Re-work / small NCR: Yes No DQA: D Date: 08/06/10
QA: N/C Closed: Date: _____

NCR: 39771		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/10	2.0	one part scrap due to having a notch/groove cut approx. in center outside edge	 08/06/10	Scrap and Destroy w/ Raphen Qty 01 only need to do	 08/06/10	 08/06/10	 08/06/10	 08/06/10
		RC water jet still had pressure in the line as it moved across the part to the next starting position	 08/06/10	•		 08/06/10	 08/06/10	 08/06/10

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>S 08/06/13 (x10)</i>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <i>F1 08/06/13 (11)</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>M-A 08/06/13 (11X)</i>
9.0	MS20426AD33	Rivet <i>E 08/06/16</i>
10.0	MS21059L3	Nut Plate <i>E 08/06/16</i>
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>E 08/06/16</i>
12.0	QC5	INSPECT WORK TO CURRENT STEP <i>S-08/06/16 (x10)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5779

Peggy/16

(11)

14.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/06/19 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

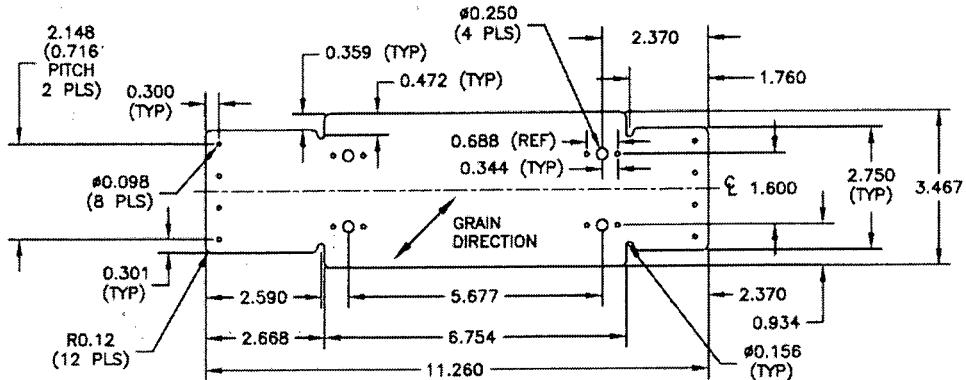
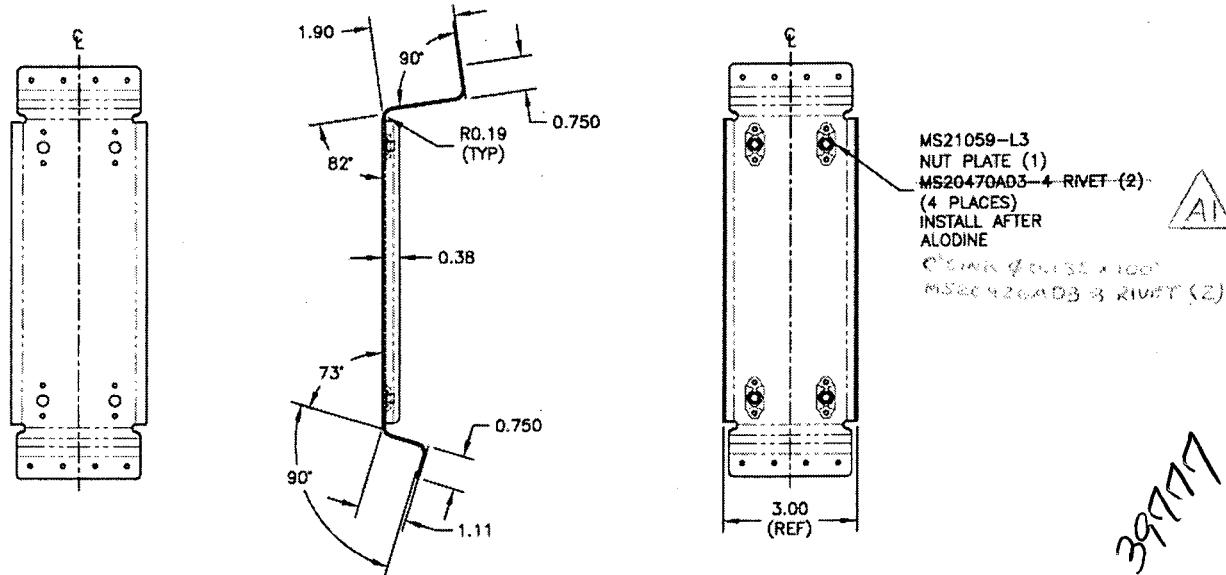
COPY 1 OF 1

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3246	SHEET 1 OF 1

DATE 04.04.21 TITLE MOUNTING BRACKET SCALE 1:4

RELEASED
04.05.07

A	04.04.21	NEW ISSUE
A1	04.06.16	CHANGE RIVET; ADDED C-SKIR

**D3246-1 FLAT PATTERN****D3246-1 BEND DETAIL****D3246-041 ASSEMBLY****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART AEROSPACE LTD	Work Order:	39771
Description: MOUNTING BRACKET	Part Number:	D3246-04
Inspection Dwg: D3246-04 (Rev: A)		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ .098	+ .064 - .001	.102	✗			
∅ 250	+ .006 - .001	.254	✗			
.300	+/- .016	.301	✗			
.301	+/- .010	.302	✗			
2.148	+/- .010	2.145	✗			
.716	+/- .010	.715	✗			
.472	+/- .010	.472	✗			
.359	+/- .010	.359	✗			
1.760	+/- .010	1.760	✗			
2.370	+/- .010	2.371	✗			
1.600	+/- .010	1.601	✗			
2.750	+/- .010	2.748	✗			
3.467	+/- .010	3.466	✗			
.934	+/- .010	.935	✗			
2.370	+/- .010	2.373	✗			
2.590	+/- .010	2.590	✗			
2.668	+/- .010	2.670	✗			
5.677	+/- .010	5.678	✗			
6.754	+/- .010	6.750	✗			
11.260	+/- .010	11.260	✗			

Measured by:	48	Audited by:	✓	Prototype Approval:	✓
Date:	9-6-10	Date:	08/06/10	Date:	17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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